

Work Order ID 98600

98600

Page 1

March-14-13 3:09:29 PM

Item ID: D3774-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Seat Bottom, LH/RH

Start Date: 3/14/13

Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/21/13

Req'd Qty: 5.00

5

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3774	Rev B								
100	HAND FINISHING THERMOFORMING	0.00							
100									
Thermoform	Memo	0.00							
Thermoforming Machine	Set up machine program D3774-1 Set up clamping frame as per folio								
110	HAND FINISHING THERMOFORMING	0.00							
110									
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								

46

13/04/17

46

13/04/17

Work Order ID 98600

March-14-13 3:09:29 PM

98600

Page 2

Item ID: D3774-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Bottom, LH/RH

Start Date: 3/14/13 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 3/21/13 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	Dry Material	0.00							
115									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: <u>240°F</u>								
	Time IN: <u>2:00 pm</u>	<u>13/04/14</u>							
	Time OUT: <u>7:00 am</u>	<u>13/04/17</u>							
120		0.00							
120	THERMOFORMING MACHINE								
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3774-1 and Folio								
	Dwg. Rev. <u>B</u>								
	Folio Rev. <u>C</u>								
	Visually inspect for proper formation of each part								

✓ DL
13/04/17
✓ DL
13/04/17

Work Order ID 98600

98600

Page 3

March-14-13 3:09:29 PM

Item ID: D3774-1 Accept: *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Seat Bottom, LH/RH
 Start Date: 3/14/13 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 3/21/13 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140	HAND FINISHING THERMOFORMING					6			JB 13/04/22
Thermoform	Memo	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
150		0.00							
150	QC2- Inspect parts off machine FAI/FAIB					6			JB 13/04/22
QC	Memo	0.00							
Quality Control	1) Check dimensions to ensure conformity to drawing tolerances.								
160		0.00							
160	QC5- Inspect part completeness to step on W/O					6			
QC	Memo	0.00							
Quality Control									

DAS
27
13 4 23

Work Order ID 98600

98600

Page 4

March-14-13 3:09:29 PM

Item ID: D3774-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Seat Bottom, LH/RH
 Start Date: 3/14/13 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 3/21/13 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo <i>ALIVE</i>	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13/4/23
13-04-23

Picklist Print

March-14-13 3:09:28 PM

Page 1
T

Work Order ID: 98600

Parent Item: D3774-1

Parent Item Name: Seat Bottom, LH/RH

Start Date: 3/14/13

Required Date: 3/21/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL
Material 10/04/21 DL

IPP Rev. C Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			110	sf	2,330.6640	10.667	53.335			

Location

MAT018

Loc Qty

2330.664

Loc Code

666.664

1664

DL.
13/04/17

64.5g ft.

DART AEROSPACE LTD		Work Order: 98600
Description: Seat Bottom		Part Number: D3774-1
Inspection Dwg: D3774	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

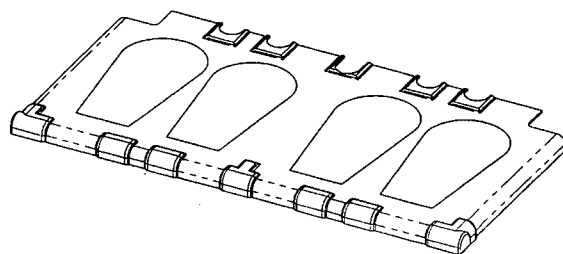
Measured by: JB	Date: 13/04/22
-----------------	----------------

TRIMMING SECTION

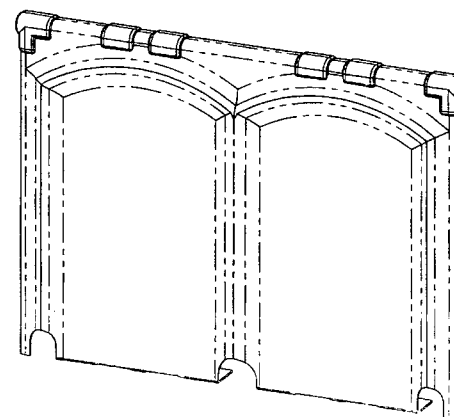
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.37	✓			
33.9	+/-0.100	33.825	✓			
17.4	+/-0.100	17.5	✓			
0.085	Min	108	✓			
0.100	Min	115	✓			
0.100	Min	115	✓			
0.100	Min	113	✓			
0.100	Min	114	✓			

Measured by: JB	Date: 13/04/22
Audited by: 27	Date: 13/4/22
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	AS



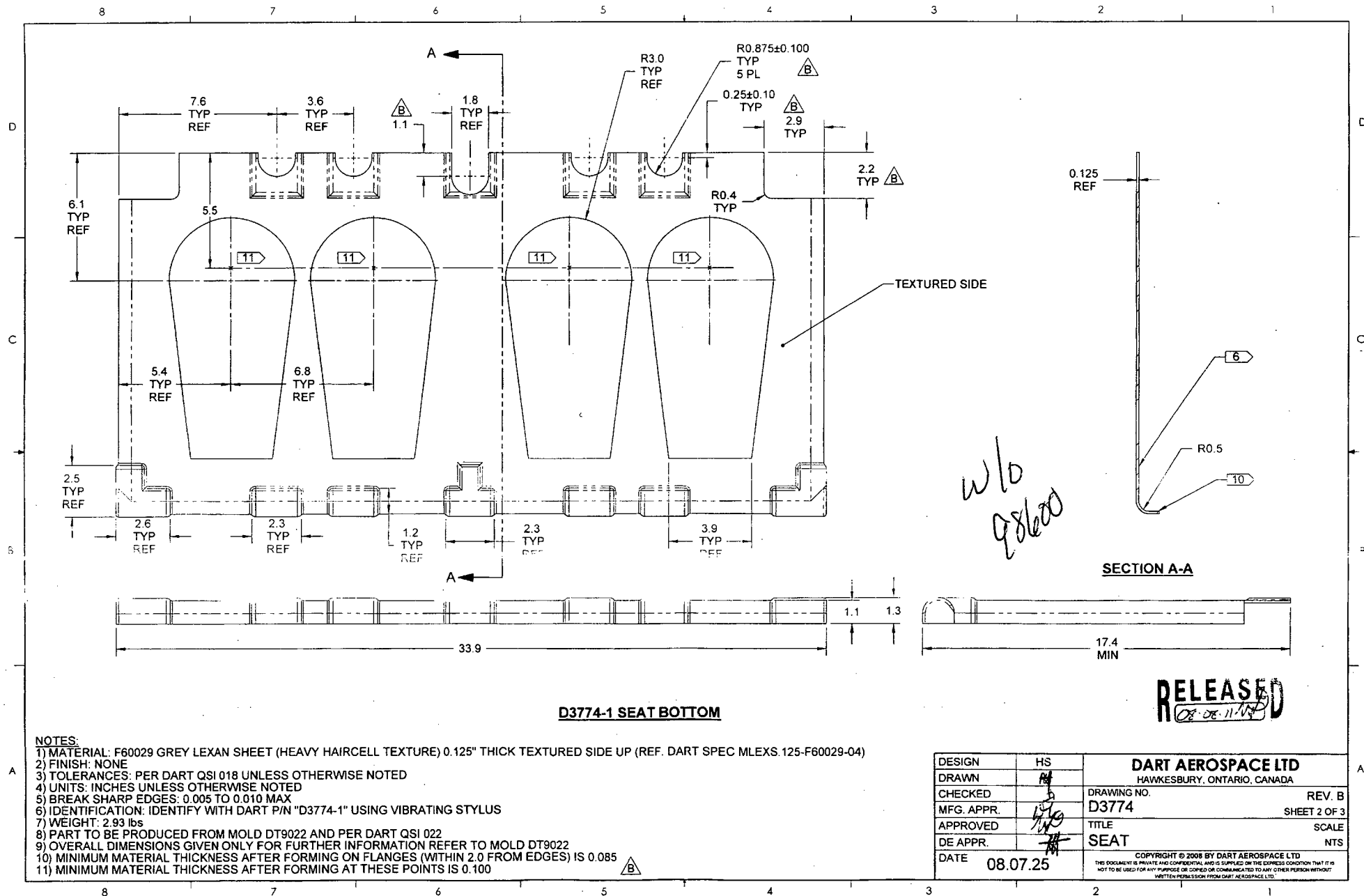
D3774-1 SEAT BOTTOM



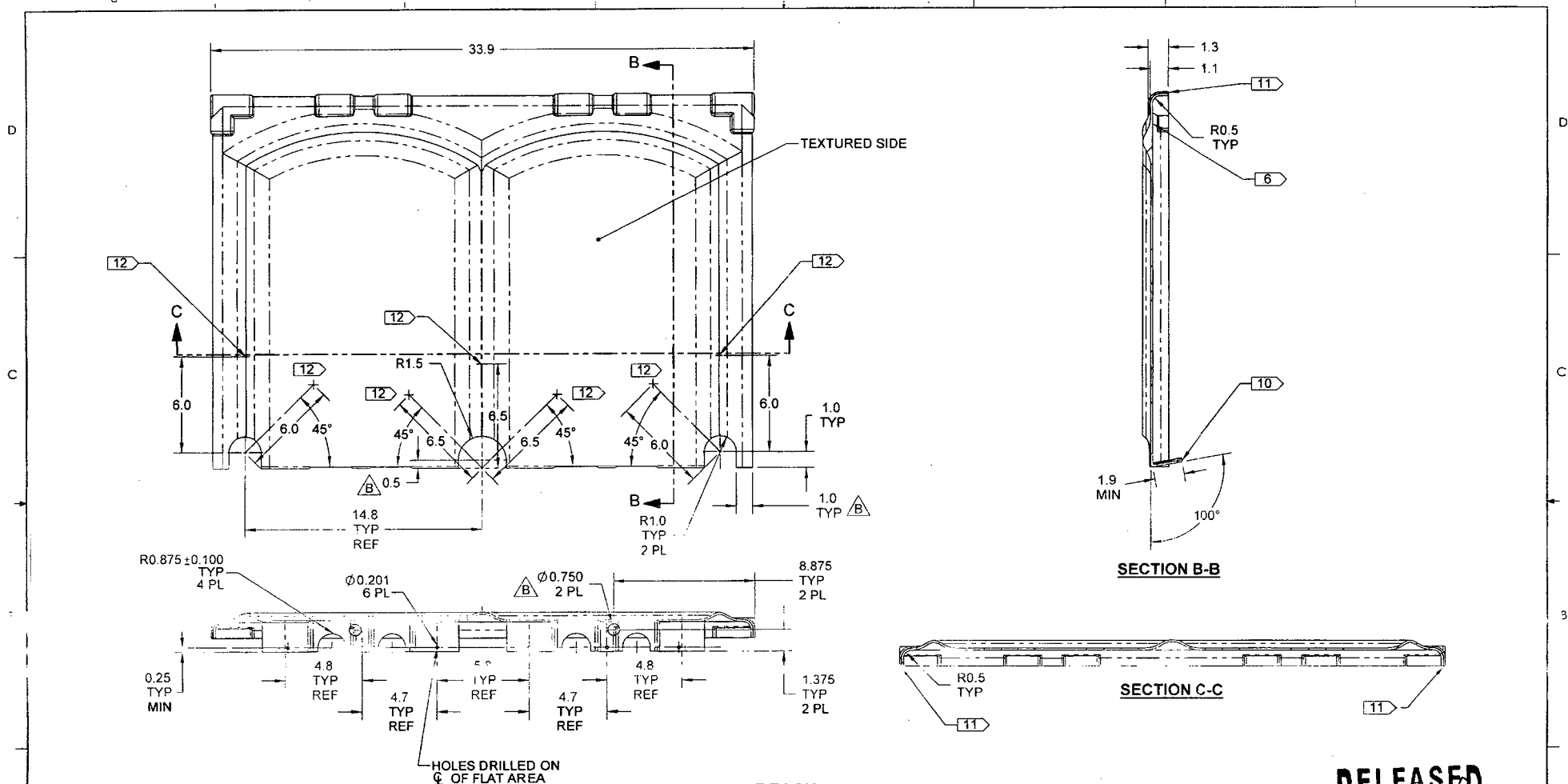
D3774-3 SEAT BACK

RELEASED
06-08-11/14

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3774 TITLE SEAT SCALE NTS	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	REV. B SHEET 1 OF 3	
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8 7 6 5 4 3 2 1



D3774-3 SEAT BACK

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 4.82 lbs
 - 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
 - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
 - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
 - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
 - 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED
08-05-11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AD		
CHECKED	LS	DRAWING NO. D3774	REV. B
MFG. APPR.	LS	SHEET 3 OF 3	
APPROVED	AD	TITLE SEAT	SCALE NTS
DE APPR.	AD	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.07.25		

8 7 6 5 4 3 2 1